



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3407-5

Job Sheet 200144



Part No: D3407-5

Job Qty: 24 pcs

Part Name: Ring



Part Weight: 0 lbs

Job Created: 9/6/19

Due Date: 10/11/19

Type: Stock *S&P*

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG D3407 REV.G IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified
By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	24 pcs		10/11/19	0.17	2.19	Waterjet - Flow		<i>2019/11/16</i>
							Waterjet - Omax		
110	QC 2	24 pcs		10/11/19	0.00	0.00	QC 2 - 1		<i>2019/11/16</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	SRB 11/20/19
115	Conventional Lathe - 1 - B4B	24 pcs	10/11/19	0.00 1.58	Conventional Lathe - 1 - B4B	11/11/21
					Conventional Lathe - 2 - B4B	
117	QC 2	24 pcs	10/11/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	11/11/21
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	QC 8	24 pcs	10/11/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	

						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	DAS
						QC 8 - 47	23
						QC 8 - 40	9-89
						QC 8 - 52	
						QC 8 - 23	19/11/21
						QC 8 - 57	
130	Packaging 3-1 - Stock - B4B	24 pcs	10/11/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	PC WA001-5
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
140	QC 21 - SA	24 pcs	10/11/19	0.00	0.00	QC 21 - SA - 21	DAS
						QC 21 - SA - 70	21
						QC 21 - SA - 53	2-88 NOV 27 2019

Part Op 100 - 1-Cut as per Dwg D3407 Dwg Rev: G Prog Rev: G 2-Break edges on manual lathe Dwg D3407

Descriptions: (175rpm)

- 110 - (QC2- Inspect parts off machine FAI/FAIB)
- 115 - (Manufacture as per dwg)
- 117 - (QC2- Inspect parts off machine FAI/FAIB)
- 120 - (QC8- Inspect parts - second check)
- 130 - (Identify as per dwg & Stock Location: _____)
- 140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-B0.250X4.000	17-4 SS H900 Bar 0.250" X 04.000"	6.3840 ft (.266 ea)	100-Waterjet - Flow - 1	S207609

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M17-4-H900-B0.250X4.000	6	24	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches ± 0.010	0.260 0.240	0.249	Initial JLOS
2	Tow Ring	3.000inches ± 0.030	3.030 2.970	3.001	"
3	Tow Ring	2.050inches + 0.012 - 0.001	2.062 2.049	2.049	"
4	Tow Ring	0.750inches ± 0.030	0.780 0.720	0.755	"

Plex 9/6/19 1:44 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____		DISPOSITION		DEPARTMENT/PROCESS						MRB (QS1042)			
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition						Completed By	
Description Work Order Deviation												Lead hand / Supervisor	
												QC / QA Coordinator	
Root Cause		FAULT CATEGORY											
☐ Operator		☐ Pressure/Forced		☐ Contamination		☐ Power Loss/Surge		☐ Positioned Wrong		☐			
☐ Manufacturing Process		☐ Bending		☐ Misaligned/off center		☐ Folio/Program		☐ Outside Tolerance		☐			
☐ Equip/Tooling		☐ Crushing		☐ BOM/Route		☐ Grain Direction		☐ Drawing		☐			
☐ Handling/Preservation		☐ Cracks		☐ Broken/Damage/Defect		☐ Weld		☐ Finish		☐			
☐ Material		☐ Crimp/Kink/Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions		☐ Wrong Stock Pulled		☐ Part Lost/Missing		☐			
☐ Product Improvement		☐ Marks/Chatter		☐ Drill Holes		☐ Out of Sequence		☐ Misread		☐			
☐ Process Improvement		☐ Mislabeled		☐ Fit/Function		☐ Off-set/Set-up		☐		☐			
☐ Human Factors		Other/Details: _____											